

Date: Wednesday, 5/23/2007 3:24:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD		
Job Number	32465					
Estimate Number	10313					
P.O. Number			Part Number	D26483		
This Issue	5/23/2007	S.O. No.	Drawing Number	D2648 REV D		
Prsht Rev	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	D:		
Previous Run	31695		Material			
Written By	<i>DR 07.05.24</i>		Due Date	6/10/2007	Qty:	200
Checked & Approved By			Um:	Each		
Comment	Est: E 02-09-18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025/A21/6aA SHEET	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 15.7500 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) <i>m104421</i> Batch: <i>M1010 S6A</i> <i>B 07-06-28</i>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <i>D</i> Prog Rev: <i>D</i>  2-Deburr if necessary <i>B 07-06-28</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>B 07-06-28</i>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<i>En 07/07/04</i> <i>x200</i> <i>Counter</i>	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<i>B 07-07-09</i> <i>04/07/10</i> <i>100</i>	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 32465

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SAD 07/07/13 200  
coated

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R560Hardcoat M107368/M104721  
1-Weld as per Dwg D2648 using Jig DT 8210  
2-Remove any weld that penetrated through Wearpadif necessary

88 07/08/13 200x

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/08/13 200

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/08/13 200

10.0 POWDER COATING POWDER COATING



m 104846

200x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

18/m.1

07/08/13

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 07/08/13 200

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: FP-17

Fd 07/08/13 200

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A.07.08.14

Job Completion



C 07/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32465
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

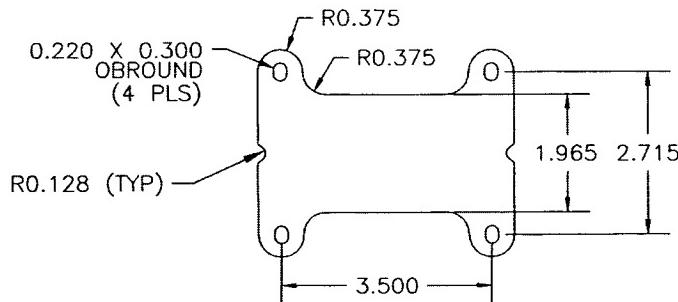
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

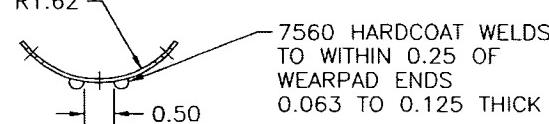
Measured by: <u>IB/mil</u>	Audited by: <u>Eas</u>	Prototype Approval:	N/A
Date: <u>01/06/29</u>	Date: <u>07/07/04</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	JL

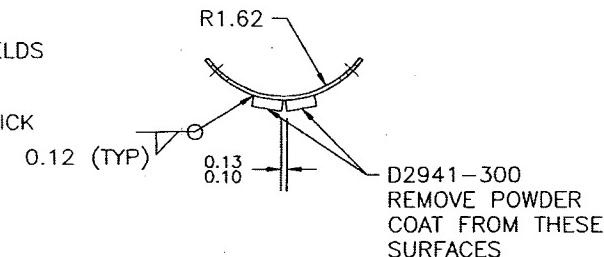
D2648-1 FLAT PATTERN



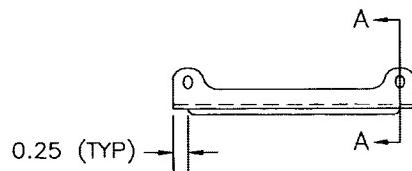
SECTION A-A



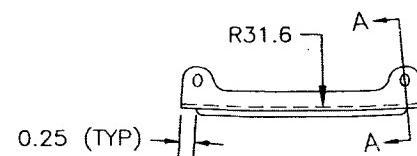
SECTION B-B



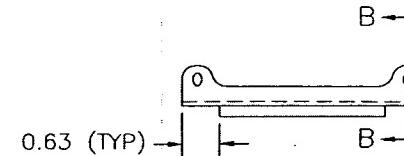
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

NO. 32465  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
ENGINEERING  
RETURN TO  
SHOP COPY  
UNCONTROLLED COPY  
LED COPY

RELEASED  
12.20 DS

COPYRIGHT  
DART

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLVIEW, WA
	RF	
CHECKED	APPROVED	DRAWING NO. REV. D D2648 SHEET 1 OF 1
		DATE TITLE SCALE 99.11.17 WEARPAD 1:2